

Deriv 55302 Rush!

Work Order ID 53503

November 6, 2009 3:09:09 PM



Page 1

Item ID: D3262-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: Cap

Start Date: 06/11/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

PP

Date:

07/11/07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3262	Rev C								

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 6.000" x 0.500" x 5.400" long Bar
Machine as per Folio FA457 and Dwg D3262
Identify for D3262-3
Debur

MMF
10/01/07

10 *0*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per dwg D3262

MMF
10/01/08

10 *0*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

MMF
10/01/08

10 *0*

Work Order ID 53503

November 6, 2009 3:09:09 PM



Page 2

Item ID: D3262-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: Cap

Start Date: 06/11/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

mk 10/01/08

10 0

140

Identify as per dwg & Stock Location: *141A*

0.00



Packaging

Memo

0.00

Packaging

10-11-11

100 SP

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/12

MF 10-01-12

Picklist Print

November 6, 2009 3:09:13 PM

Page 1

Work Order ID: 53503



Parent Item: D3262-3RevC



Parent Item Name: Cap

Start Date: 06/11/2009

Required Date: 13/11/2009

Comments: IPP RevD: revC as per dwg 09.11.06 DD verified by:JLM

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.500X06.00 0		Purchased	No				f	54.8500	9.6000			



6061-T6 Bar .500 x 6.00

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	54.85	
110912	12	
111321	2.85	
112567	40	

M 105145

mmf

4.96
4.975

DART AEROSPACE LTD		Work Order:	53503
Description: Cap		Part Number:	D3262-3
Inspection Dwg: D3262 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070 x 45°	+/-0.010	.075 x 45°	✓			
0.45	+/-0.030	.44	✓			
R0.063	+/-0.010	R.063	✓			
0.080	+/-0.010	.080	✓			
0.33	+/-0.030	.32	✓			
Ø5.005	+0.010/-0.000	Ø5.005	✓			
0.688	+0.015/-0.000	.688	✓			
3.25	+/-0.005	3.247	✓			
0.875	+/-0.010	.874	✓			
Ø0.516	+0.005/-0.000	Ø.517	✓			
Ø5.165	+/-0.010	Ø5.166	✓			
0.083	+0.015/-0.000	.084	✓			
Ø0.580	+0.005/-0.000	Ø.580	✓			

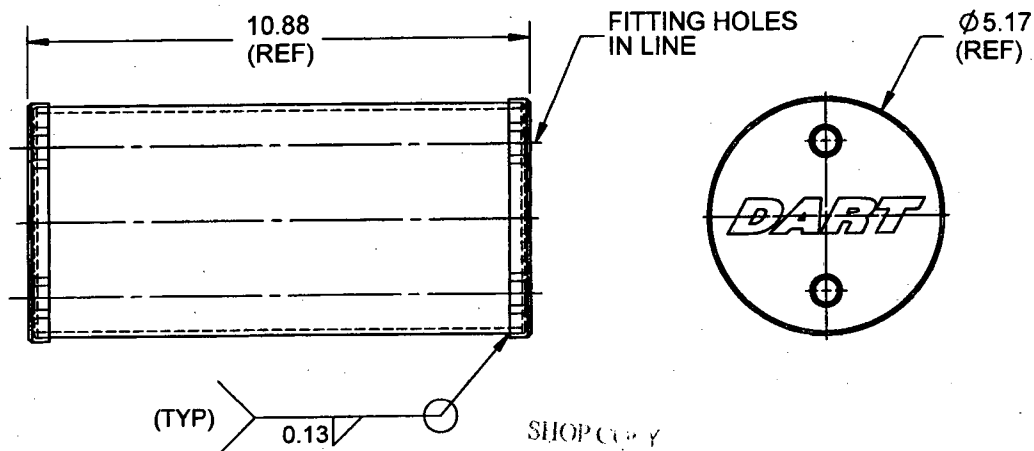
Measured by: <i>MMF</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 10/01/08	Date: 10/01/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue P/O D3262-041	KJ/JLM	
B	05.04.28	Dimensions and tolerances revised	KJ/JLM	
C	06.09.27	Dimensions revised per rev. C	KJ/JLM	
D	07.09.06	0.080 was 0.090	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	REV. C SHEET 1 OF 2
DATE 06.08.31		TITLE FUEL PURGE CANISTER SCALE 1:4	
REV	DATE	DESCRIPTION	
A	04.05.06	FIRST ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	
C	06.08.31	Ø5.165 WAS Ø5.190	

RELEASED
06.09.19 *[Signature]*



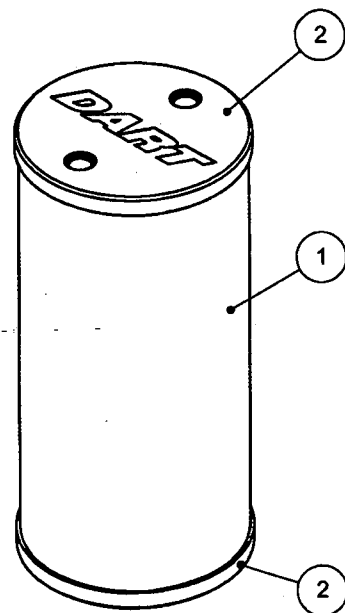
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO ANY SETTING
WITHOUT A FULL
WORK ORDER
NO. 53503
PH 09-11-4

D3262-041 CANISTER ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER

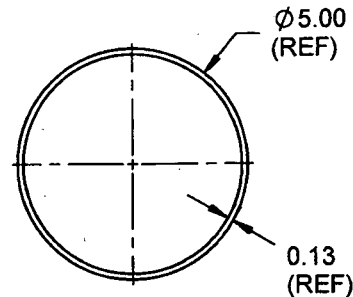
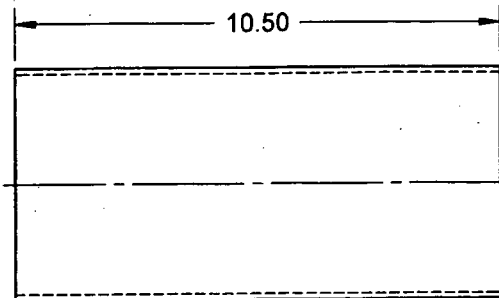


COPYRIGHT © 2004 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>PH</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3262	REV. C SHEET 2 OF 2
DATE 06.08.31	TITLE FUEL PURGE CANISTER		SCALE 1:4

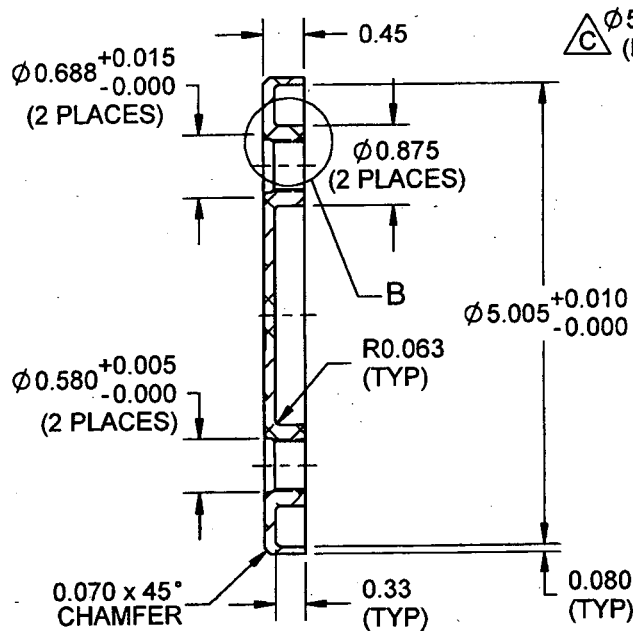
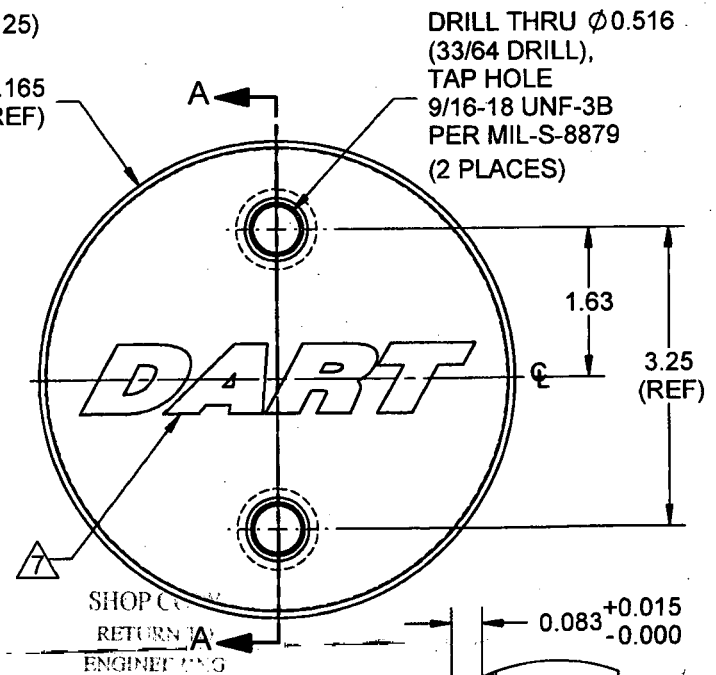


RELEASED

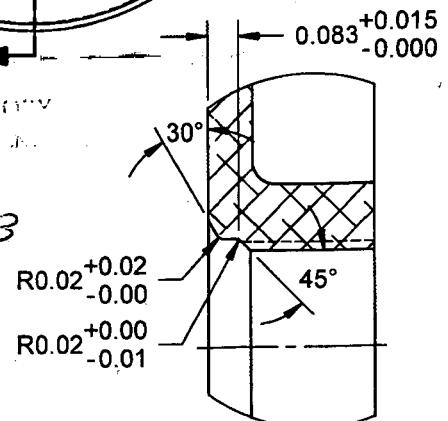
06.09.19

D3262-1 TUBE

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)

**SECTION A-A**
SCALE 1:2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER NO. 53503

**DETAIL B**
SCALE 2:1**D3262-3 CAP**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)

COPYRIGHT © 2004 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

L Lacelle

From: Mike Petsche [mpetsche@dartaero.com]
Sent: January 6, 2010 8:13 AM
To: 'L Lacelle'
Cc: 'Roberto Fuentes'; 'David Shepherd'
Subject: RE: canisters

Knock yourself out

(Yes....the B205 ones are ok. Just the 212/412 are the issue. Eng will sign off)

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, January 06, 2010 7:29 AM
To: mpetsche@dartaero.com
Cc: 'Roberto Fuentes'; 'David Shepherd'
Subject: canisters
Importance: High

We have another 205 fuel purge canister to ship next Friday, but the canisters are still under review...can we make any of these to help this customer out? Need an answer asap please

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd